



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-9-1

Job Sheet 192209



Part No: C45-9-1

Job Qty: 12 pcs

Part Name: Clock Spring Cover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C45-9-1 REV 6 IPP Rev. A 19.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-2500Y - 1	12 pcs		4/30/19	0.00	12.00	SL-2500Y - 1		
110	QC 2	12 pcs		4/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S167968



Part: C45-9-1

Job No: 192209

Serial No/Batch: S167968

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/31/19

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					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
120	NV5000 - 1 - B4B	12 pcs	4/30/19	0.00 24.00	NV5000 - 1 - B4B	
					NV5000 - 2 - B4B	PT 19-04-05 DJ 19-04-05
130	QC 2	12 pcs	4/30/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	Sc. 19-04-06
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
150	QC 8	12 pcs	4/30/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.A 19-04-07
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	

180 Outsource - 4 - Anodize	12 pcs	4/30/19		GRO002-VC	04/07/2019 PL
190 Packaging 2-1 - Receive - B4B	12 pcs 17 pcs	4/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	DP APR 15 2019
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 -	
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200 QC 6	12 pcs	4/30/19	0.00	0.00	B4B	
					QC 6 - 42	DAS
					QC 6 - 9	APR 16 2019 40
					QC 6 - 68	9-89
210 Packaging 3-1 - Stock - B4B	12 pcs	4/30/19	0.00	0.00	QC 6 - 61	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

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3/19/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

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				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	APR 17 2019
Part Op 100 - 1-Machine as per folio FC <u>721</u> FOLIO REV: <u>AA</u> DWG REV: <u>6</u> 2-Debur Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - 1-Machine as per folio FC <u>721</u> FOLIO REV: <u>AA</u> DWG REV: <u>6</u> 2-Debur 150 - (QC8- Inspect parts - second check) 180 - Issue P/O: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant - Material type; 6061T6 -Certificate of Conformity is required 190 - (Receive & Inspect for Damage & Mat'l Certs) 200 - (QC6- All purchased or subcontracted products) 210 - (Identify as per dwg & Stock Location: _____) 220 - (QC21- Final Inspection - Work Order Release) <u>100-see pec for programming BATCH # FOR NV-SWC OPERATING</u>					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R2.750	6061-T6 Round Bar 2.750"	1.1520 ft. (096 ea) <u>1230</u>	100-SL-2500Y - 1	<u>5/3/150</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-2500Y - 1	M6061T6R2.750	1	16	0	
Part Specifications					
Specifications could not be found.					

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

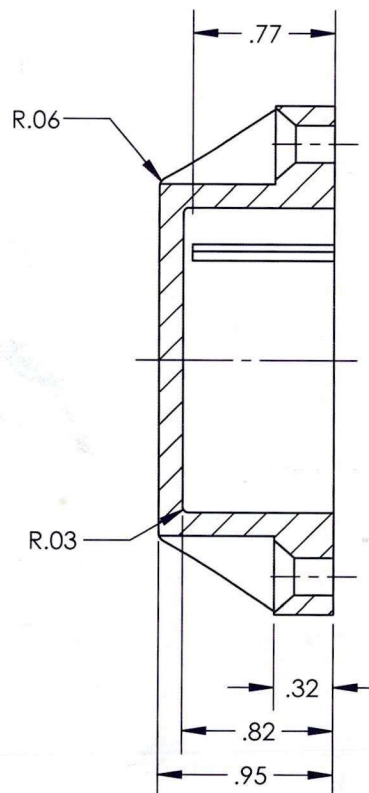
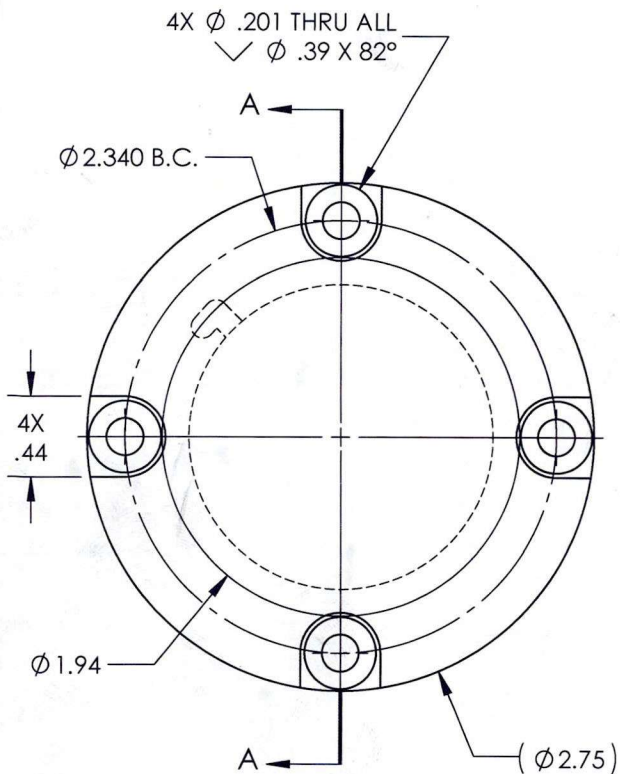
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

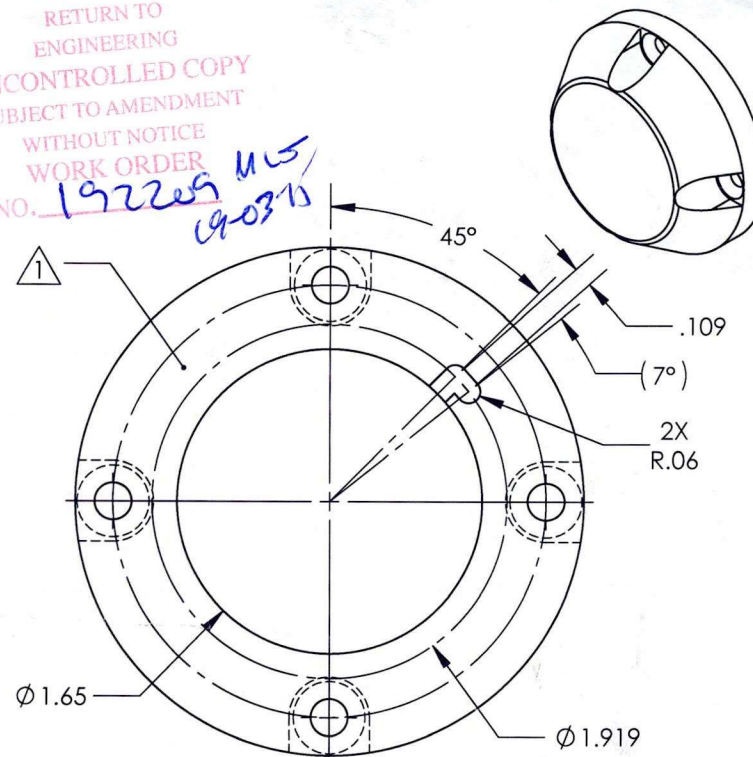
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM.	9/14/2012	RJC	
5A		CH'D OUTSIDE DIAMETER WAS Ø2.750 IS Ø2.75.	9/5/2013	RJC	JAG
6	14-0126	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D DIM WAS Ø2.75 IS (Ø2.75). CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/13/2014	DPD	RW

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192209 M/S
190311



SECTION A-A



NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE CLOCK SPRING COVER	
DWG NO. C45-9-1	REV 6
MAT'L 6061	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Wed</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH BLACK ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 5/14/1997
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-9-1	1	CLOCK SPRING COVER	6061	Ø2-3/4 X 1-1/16



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO043150



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043150

PO Date: 4/9/19

Due Date: 4/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189386	C45-2-1	Sideplate - MRK Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/15/19	3 pcs	0 pcs	3 pcs	\$6.00/pcs	\$18.00
APR 15 2019 DP											

Line Item Note *** RUSH - RUSH - RUSH ***
PLEASE DELIVER ASAP

2	192209	C45-9-1	Clock Spring Cover -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/15/19	17 pcs	0 pcs	17 pcs	\$6.00/pcs	\$102.00
APR 15 2019 DP											

Line Item Note *** NEED BACK APRIL 18,2019 ***



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PURCHASE ORDER

PO043150



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190534	RBW109-3130-34-1-3	Rod, Ø2-5/8 X 11-1/2 -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X4	-	4/15/19	4 pcs	0 pcs	4 pcs	\$30.00/pcs	\$120.00
APR 15 2019 DP											

Line Item Note *** NEED BACK APRIL 18,2019 ***

4	192395	RB877212-08-21	Cap, Ø2 x 1-3/8 -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X6	-	4/15/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
APR 15 2019 DP											

Line Item Note *** NEED BACK APRIL 18,2019 ***



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PURCHASE ORDER

PO043150



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	190616	20NR-10	Spacer (note: please use the BLUE ones with 8NR and the GOLD ones with 20NR) (Outsource process-Anodize per QSI017 4.1.10.1)-Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR GOLD, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed X1	-	4/15/19 APR 15 2019	1 pcs	0 pcs DP	1 pcs	\$12.00/pcs	\$12.00
Line Item Note *** NEED BACK APRIL 18,2019 ***											
	191265			Firmed	-	4/15/19	9 pcs	0 pcs	9 pcs	\$12.00/pcs	\$108.00
Sub Total:							10	0	10		\$120.00
Grand Total:											\$480.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/10/19 8:40 AM dart.Lussier.Patrick


Certificat de Conformité / Certificate of Compliance


0 1 8 3 6 3 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9

Tel: 514-335-3666

Fax: 514-335-3868

www.groupaltech.com

Bon de Livraison / Packing Slip
018363- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Apr-2019		SVETLANA DORZHIYEVA		043150				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities				
Job # / Ref #				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C45-2-1 Rev.	C45-2-1 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	3	3	0	0	0
2	C45-9-1 Rev.	C45-9-1 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	17	17	0	0	0
3	RBW109-3130-34-1-3 Rev.	RBW109-3130-34-1-3 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4	0	0	0
4	RB877212-08-21 Rev.	RB877212-08-21 01 -ANO-RED [ANODIZE RED] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	6	6	0	0	0
5	20NR-10 Rev.	20NR-10 01 -ANO-GOLD [ANODIZE GOLD] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	1	1	0	0	0
6	20NR-10 Rev.	20NR-10 01 -ANO-GOLD [ANODIZE GOLD] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	9	9	0	0	0

Notes Additionnelles / Additional Notes
**Epaisseur réelle
Actual Thickness**
**Inspecteur Qualité
Quality Inspector**
**Réçu par
Received By**

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.